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CLAIM AMENDMENTS:

Claims 1 to 89 cancelled

90. (new) A device for producing a printed useful part and a waste portion residue by punching printed cardboard, cardboard packaging, corrugated board, paper and similar substrates using a rotary punching process, the device comprising:
- a first rotating processing roller;
 - a second rotating processing roller, said second processing roller cooperating with said first processing roller to define a working gap between said first processing roller and said second processing roller;
 - tool parts disposed on at least one of said first processing roller and said second processing roller to process a useful part and a waste portion from the substrate by cooperating with at least one of said first processing roller and said second processing roller to punch out the substrate in said working gap ;
 - at least one gripper disposed on at least one of said first processing roller and said second processing roller, said at least one gripper effecting a register-controlled transport of the substrates as printed sheets; wherein a downstream gripper acting on the substrate fed from the first processing roller and the second processing roller is disposed at any one of a delivery roller, a transfer roller, or a downstream arm.
91. (new) The device of claim 90, wherein at least the substrates without punching or with pre-punching are transported in a register controlled fashion.

92. (new) The device of claim 90 wherein the device is integrated in a processing line such that it is register controlled and at least an auxiliary device is provided in the work cycle of the processing line before or after the device.
93. (new) The device of claim 90, wherein said first and said second processing rollers bear said tool parts in an exchangeable manner.
94. (new) The device of claim 90, further comprising a laser punching unit disposed proximate said working gap.
95. (new) The device of claim 90, wherein said first and said second processing rollers comprise magnetic cylinders on which said tool parts are held in an exchangeable fashion, said tool parts comprising at least one of punching, stamping, furrowing and embossing tools.
96. (new) The device of claim 90, further comprising a downstream disintegrating means.
97. (new) The device of claim 96, wherein said disintegrating means cooperates with said disposal device via transport pipes.
98. (new) The device of claim 97, wherein said disintegrating means is connected to a waste bin via transport pipes.

99. (new) The device of claim 98, wherein said disintegrating means is disposed outside or inside a machine.
100. (new) The device of claim 90, wherein a plurality of disposal devices are provided for disposal of the waste portion.
101. (new) The device of claim 100, wherein said plurality of disposal devices are structured and positioned for disposal of the waste portion at a surface and/or inner portions of said first and said second processing rollers.
102. (new) The device of claim 101, wherein said plurality of disposal devices are structured for disposal of the waste portion through further transport using a third gripper.
103. (new) The device of claim 90, wherein at least one of said first and said second processing cylinders is a hollow cylinder suitable for accepting the waste portion.